

Work Order ID 67924

Monday, April 04, 2011 4:04:06 PM

Page 1

Item ID: D4017-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Short Basket Base Assembly (350)

Start Date: 4/11/2011 Start Qty: 1.00

Required Date: 4/22/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *mf*Date: *11-04-04* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4017

C

100

Weld per dwg A/R S.S. rod Batch: *M114649* 0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D4017 using DT9610B
inspect before welding mesh
2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary
and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D4017
take lid to locate hinge and bracket

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11-04-16 (12)*11-04-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing



Setup Start



Stop



Cust Item ID:

Customer:



S 4/04/11

(70)

1 0 2/10/11

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

1116964

0.00

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 1:00pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 1:30pm

***** 2nd coat if necessary*****

2ND COAT:

START TIME: /

OVEN TEMPERATURE: /

FINISH TIME: /

1 0 21 11/04/11

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11 11 04 11/04/11

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Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



HandFinish

Assemble as per dwg

0.00

Memo

0.00

Hand Finishing

ES 4/04/11

160



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

Sub 4/70

170



Packaging

Identify as per dwg & Stock Location

0.00

Memo

0.00

Packaging

GA
Wp
67920 *ES 4/04/11*

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/2011

MF

17-04-20

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 67924

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/11/2011


Required Date: 4/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D4017-1 		Manufactured	No			100	Each	0.0000	1	1			
------------------------------------------------------------------------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--


Rib													
✓ D4018-1 		Manufactured	No				Each	5.0000		1			

Rib													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		5							
				67039		5							

D4018-1 is the same as D4017-3

✓ D4017-5 		Manufactured	No			100	Each	1.0000	1	1			
--------------------------------------------------------------------------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Hinge Rib													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		1							
				67098		1							

✓ D4017-7 		Manufactured	No			100	Each	3.0000	1	1			
--------------------------------------------------------------------------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Rib													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		3							
				66885		3							

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 67924

Parent Item: D4017-041






Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/11/2011

Required Date: 4/22/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4017-9	Manufactured	No	100	Each	4.0000	2	2	
								
Rib								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA006	4				
			66886	4				
✓ D3916-041	Manufactured	No	100	Each	7.0000	2	2	
								
Rib Assembly								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	7				
			65921	1				
			67276	6				
✓ D3916-5	Manufactured	No	100	Each	5.0000	1	1	
								
Light Rib								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	5				
			66696	5				
✓ D4034-041	Manufactured	No	100	Each	3.0000	1	1	
								
Aft Upper Rib Assembly								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA006	3				
			66884	3				
✓ D4034-043	Manufactured	No	100	Each	2.0000	1	1	
								
Fwd Upper Rib Assembly								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA006	2				
			66883	2				



B67978 (2x) SY 11.04.14



SY 11.04.14



B67979 (1x) SY 11.04.14



B67980 (1x) SY 11.04.14



B67981 (1x) SY 11.04.14

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/11/2011


Required Date: 4/22/2011

Start Qty: 1.00


Required Qty: 1.00

✓ D2581 Manufactured No 100 Each 32.0000 2 2

 Mounting Bracket

Location	Loc Qty	Loc Code
WA005	32	
66500	10	
66806	22	

✓ D3913-15 Manufactured No 100 Each 5.0000 1 1

 Wide Handle Plate

Location	Loc Qty	Loc Code
WA	3	
67751	3	
WA005	2	
66695	2	

✓ D4016-1 Manufactured No 100 Each 31.0000 3 3

 Hinge Half, Base

Location	Loc Qty	Loc Code
WA	18	
66418	0	
67473	18	
WA005	13	
66418	13	

✗ D4020-3 Manufactured No 100 Each 1.0000 1 1

 Mesh (350 Basket Short, Base)

Location	Loc Qty	Loc Code
WA	1	
67097	1	

W/O:		WORK ORDER CHANGES					
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Page 4

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Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/11/2011

Required Date: 4/22/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4020-11

 End Mesh, Basket

Manufactured No

100 Each

14.0000

2

2



SY 11.04.14

Location

Loc Qty

Loc Code

WA

14

61306

1

67094

4

67458

9

(1x)
(1x)

Manufactured No

150 Each

696.0000

2



JB

Location

Loc Qty

Loc Code

ST504

696

46064

696

100 Each

21.0000

3



46064

SY 11.04.14

Location

Loc Qty

Loc Code

WA

13

67474

13

WA005

8

66697

8

(3x)

Manufactured No

150 Each

9.0000

2



2

✓

JB

Location

Loc Qty

Loc Code


WA005

9

67008

9

67008

D2931

 Bumper

✓ D4021-1

 Handle Plate

D4021-5

 Blanking Plate

Monday, April 04, 2011 4:04:01 PM

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Page 4

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Monday, April 04, 2011 4:04:02 PM

Page 5

Work Order ID: 67924

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/11/2011

Required Date: 4/22/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-10A Purchased No
Bolt

150 Each 34.0000 6 6 ✓



JB L

Location Loc Qty Loc Code

ST351 34

116400 34

AN960JD8 NAS1149DN832J Purchased No

150 Each 0.0000 2 2



116400
117316 JB L

Washer
MS20600-AD4W3 Purchased No
Cherry Rivets

150 Each 931.0000 2 2 ✓



JB L

Location Loc Qty Loc Code

ST321 494

111636 494

WA018 437

107939 437

MS21042L3 Purchased No

150 Each 2,074.000 6 6 ✓



111636
6
JB L

Nut

Location Loc Qty Loc Code

ST300 2074

116391 474

116540 800

116549 800

NAS1149F0332P Purchased No

150 Each 22.0000 12 12



JB 117317 L

WASHER

Location Loc Qty Loc Code

ST275 22

18057 22

Monday, April 04, 2011 4:04:02 PM

Shop Packet Print

Page 5

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

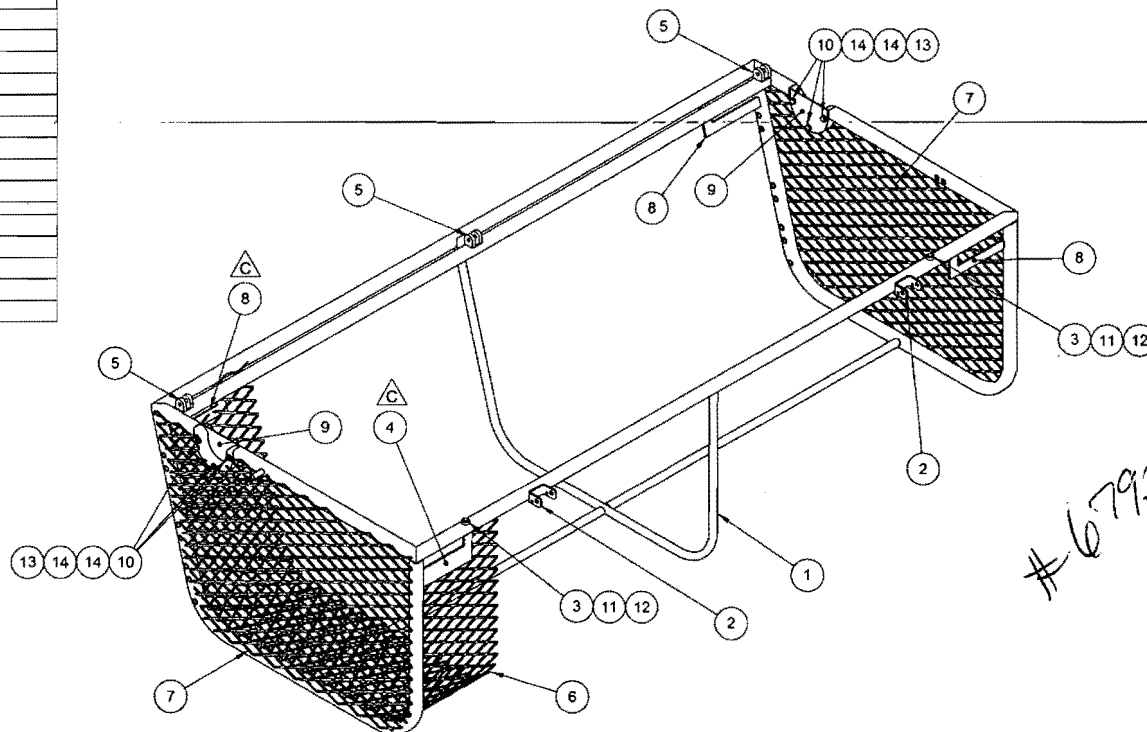
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET BASE ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-596
RELEASED
10.08.12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN			
CHECKED			
MFG. APPR.	J.F.S.		
APPROVED			
DE APPR.			
DATE	10.07.23		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4017** REV. C
SHEET 1 OF 5

TITLE **SHORT BASKET BASE ASSY (350) _NTS** SCALE

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8 7 6 5 4 3 2 1

D

C

B

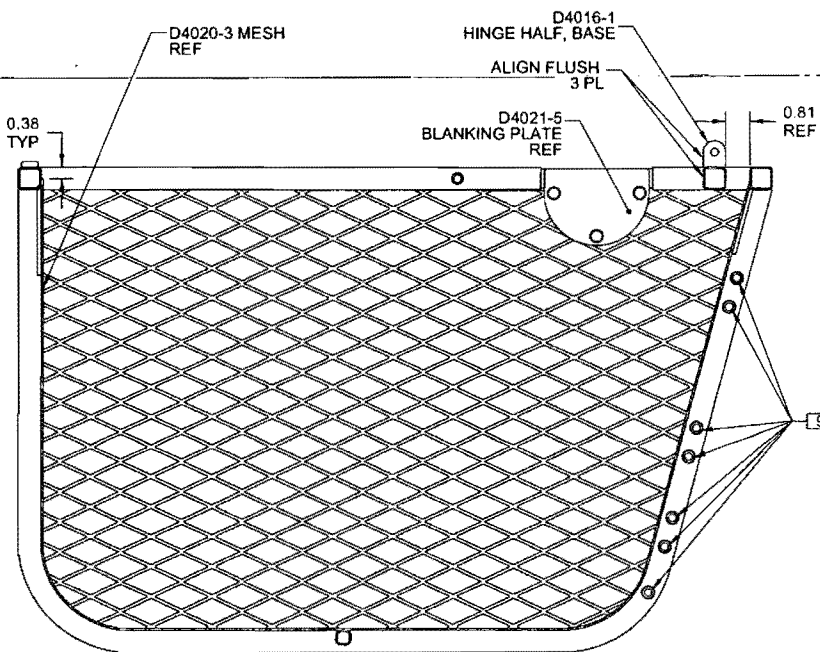
A

D

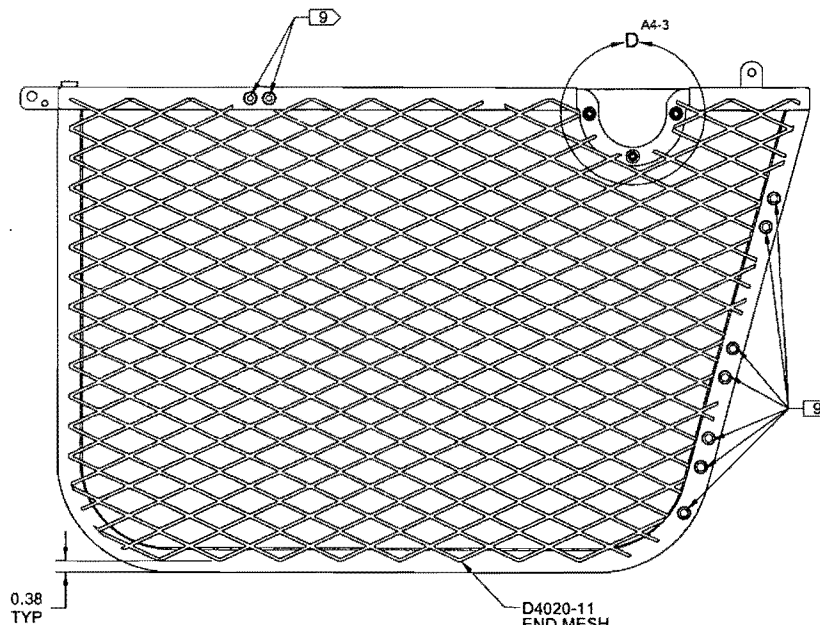
C

B

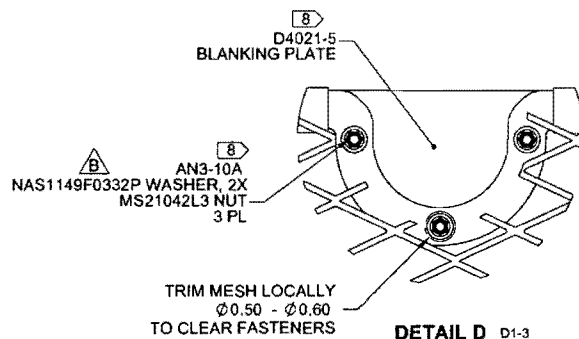
A



SECTION A-A A5-2



SECTION B-B A2-2



DETAIL D D1-3 B8-2

67924

RELEASED
10.08.12

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	J.P.	DRAWING NO.	REV. C
MFG. APPR.	J.F.S.	D4017	SHEET 3 OF 5
APPROVED	J.M.	TITLE	SCALE
DE APPR.		SHORT-BASKET-BASE ASSY (350) -NTS-	
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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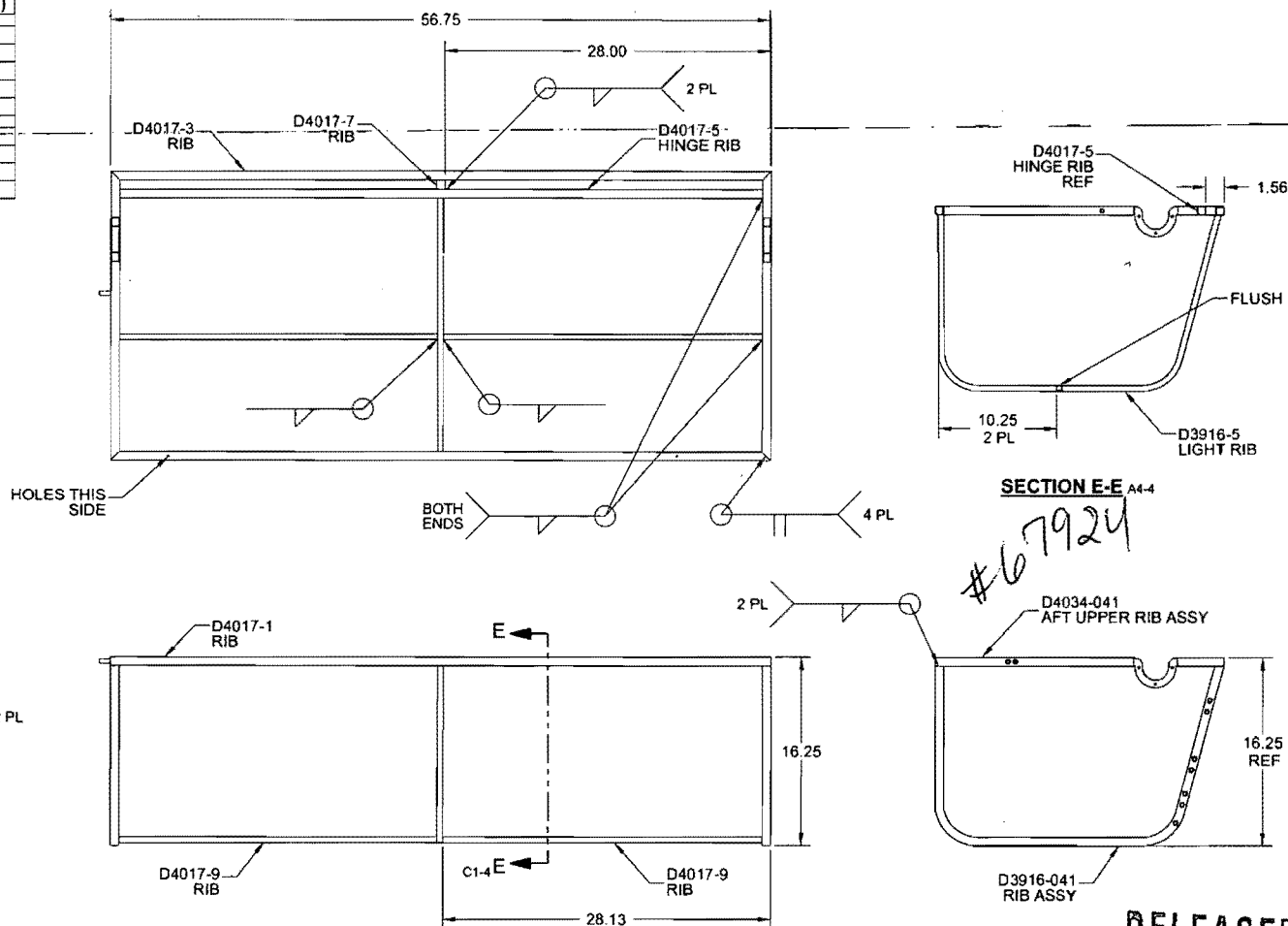
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	1	D4017-7	RIB
5	2	D4017-9	RIB
6	2	D3916-041	RIB ASSY
7	1	D3916-5	LIGHT RIB
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.26 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

DESIGN	AKS	DART AEROSPACE LTD	
DRAWN	AKS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AKS	DRAWING NO. D4017	REV. C
MFG. APPR.	SYS. BIL	TITLE	SHEET 4 OF 5
APPROVED	JUN	SHORT BASKET-BASE ASSY (350) NTS	SCALE
DE APPR.	#		
DATE	10.07.23		

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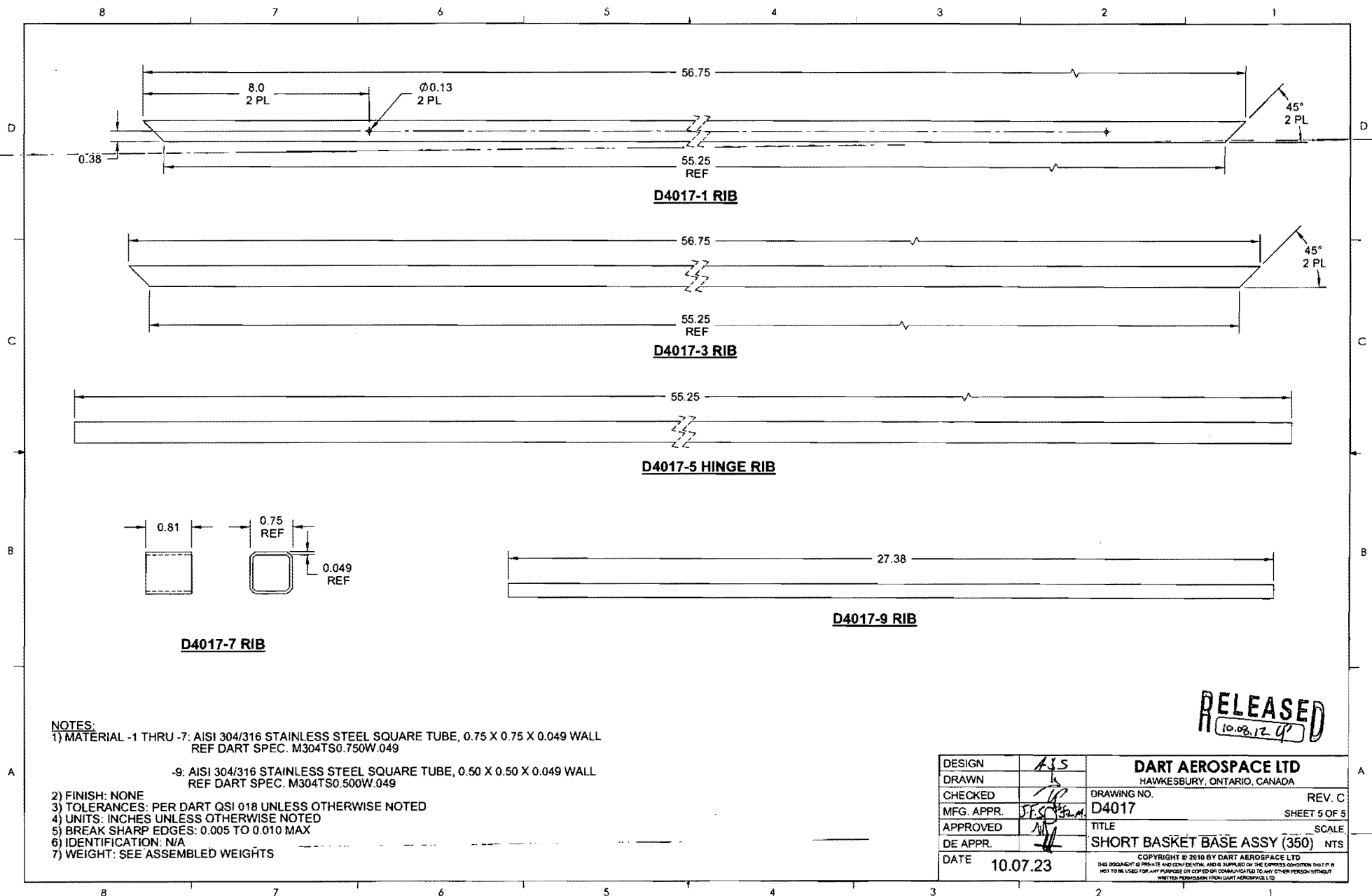
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries